

Work Order ID 92086

• October-23/12 10:34:11 AM

QC

Quality Control

D350-615-041 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Ground Handling Wheel Modification **Start Date:** *50^{*} 23/10/2012 Start Oty: 50.00 Cust Item ID: Required Date: 06/11/2012 Req'd Qty: 50.00 **Customer:** Reference: Run Start Process Plan: MLJ Date: 12-10-23 Tooling: Approvals: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D350-615-041 В 100 0.00 *100* 0.00 Memo . Document Control Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003 110 *110* Small Fab 0.00 Memo Small Fab Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts*** 120 QC5- Inspect part completeness to step on W/O 0.00 *120*

0.00

Memo

NCR: \	Yes /	No				WORK ORDER NON-	COI	NFORM	/ANCE / UPDATE		·		
					·						QA Closed:	Date	e: ९
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descrij	otion of work order update		Initial	. Action		Sign &		
Cause		ate	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						E	ALU	T CATEC	SORV.				
Landir	ng Gear	,				General	701	- CATE	, on the second				
•	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Grain Oute Hardware /Damaged Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Short Misread Offset					tolerance t ssing /rong Gurge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

• October-23-12 10:34:11 AM D350-615-041 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Ground Handling Wheel Modification **Start Date:** *50* 23/10/2012 **Start Qty: 50.00 Cust Item ID: Required Date:** 06/11/2012 Req'd Qty: 50.00 **Customer:** Reference: Run Start Approvals: Process Plan: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 QC4- 100% Inspect kits for completeness *130* QC Memo **Quality Control** 140 0.00 *1/0* Packaging 0.00 Memo Packaging Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 150 QC21- Final Inspection - Work Order Release 0.00 *150* QC 0.00 Memo Quality Control

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NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORI	MANCE / UPDATE		QA Closed:	Date	a· ¥
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Work Ord	er:					DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
Part No.						Rework Scrap Use-as-is	Skid-tube Crosstube Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR f	No					Work Order Update		mem	noforming Finis Large Fab Compo		Recystor	Supplier	Other
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Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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	Cracks					Broken/Damaged Burrs	Ŀ	4	on Incomplete		Part Incorre	<u> -</u>	Weld
	-	Crushed/0	Crimped.		,	Burrs	L	4	ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
	\vdash	Cuffs				Containination	<u> </u>	Mainte		<u> </u>	Part Moved		
		Heat Trea				Countersink	<u> </u>	Mislabe		ļ	Positioned V	_	
		Inspection		Tube		Cut Too Short	<u> </u>	Misreac		<u> </u>	Power Loss/	Surge	Other
	-	Ripples in			_	Drill Holes	<u> </u>	Offset					
	Torque Waves in Extrusion					Drawing	Out of C	Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

Picklist Print

October-23-12 10:34:15 AM

Work Order ID: 92086

92086

D350-615-041

D350-615-041

Parent Item Name: Ground Handling Wheel Modification

Start Date: 23/10/2012

Required Date: 06/11/2012

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

Parent Item:

IPP Rev:K

Removed Manufacturing 05-12-05 JLM IPP Rev:L

revise hom DD 10.03.18 verified by: II M

1	evise bom DD 10	.03.18 verified by	/:JLM										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041		Manufactured	No			110	Each	8.0000	1	50		1/1/2	~
D2282-04	41								**	4	29	208	8 ~8-(-)
. f-				Location	l	Loc	<u>Oty</u>	Loc Code			0 10		
		•		ST261	91669		8				- [3	86	9/07
D2282-043		Manufactured	No		91009	110	8 Each	10.0000	1 -	50 /	7/15	913	013
D2282-04	4 3		t						**	4	30/10	/28	
				Location		Loc (<u>Oty</u>	Loc Code		//	,		
				GA			10		<u> </u>		- B	920	989
				é ·	74934 83272] 9		_		-		7
5/16-18-015C		Purchased	No	,		110	Each	427.0000	3	150	-		
5/16-18-0 SS Bolt 5/16-18 1.5" L	15C								**		52)	
				Location		, Loc C	Qt <u>y</u>	Loc Code					•
				ST522	110242		427	,			-		
					119343 120208		77 350		_	150	- ;		
D3015-3		Manufactured	No		· 	110	Each	159.0000	3	150		5	
D3015-3									**		~	K	
_ocknut ·							\$		1	Y RI	0750	<u></u>	
	•			Location		Loc C		Loc Code	4		7/0/	\mathcal{S} ,	
				ST023	78314	1,4	159 30		70	X.U	180	ン ・	

78314 83565 : 129

DQA:	Date: •
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed:	Date:
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCE	ESS
Rework Skid-tube Crosstube Wat Scrap Machining Small Fab Prod. Eng. Use-as-is Thermoforming Finishing Rec/Store/Pack	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verif	fication QC Inspector
Doc/Data .	
Equip/Tooling	
Operator	
Material .	
Setup Setup	
Other	
Process	
Supplier	
Training	
Unapproved	
FAULT CATEGORY	
Landing Gear General Bending Bend Grain Ovalized	Pressure/Forced
├ ─ │	⊢
	Weld
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing	Wrong Stock Pulled
Cuffs Contamination Maintenance Part Moved	wrong stock runed
Heat Treat Countersink Mislabeled Positioned Wrong	
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge	Other
Ripples in Bend Drill Holes Offset	Louise

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish Folio

Picklist Print

October-23-12 10:34:15 AM

Work Order ID: 92086 *92086* Parent Item: D350-615-041 *D350-615-041* Parent Item Name: Ground Handling Wheel Modification Start Date: 23/10/2012 **Required Date:** 06/11/2012 Required Qty: 50.00 **Start Qty: 50.00** 5/16WC Purchased No 110 Each 974.0000 12 600 *5/16WC* ** SS Flat Washer 5/16 FW516S1 Location Loc Qty Loc Code ST377 954 COOX 120262 954 ST522 20 120208 20 7/16-14-050C Purchased No 110 Each 184.0000 50 ** SS Bolt 7/16 5" Long (92198A672) Location Loc Qty Loc Code ST379 8 117359 ST383 176 120146 176 D3015-5 Manufactured No 110 Each 141.0000 50 ** SS Nylock Nut 7/16 Location Loc Oty Loc Code ST023 141 74906 141 7/16WC Purchased No · 110 Each 571.0000 100 ** SS Flat Washer 7/16 Location Loc Oty Loc Code ST378 71 71 ST522 500

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Work Orde	a.r.				DISPOSITION		. <b>A</b>	/PROCESS				
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Part N	No				Scrap	Machining Small Fab Prod. Eng. Coor.						
NCR N	No				Use-as-is Work Order Update	]	1	~ <del>  </del>	inishing nposite	Rec/Sto	Other	
Root				Descri	ption of work order update	1	Initial	Action		Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Cł	nief Eng	Description	1	Date	Verification	QC Inspector
Doc/Data												
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Landir	ng Gear				General		_			_		<u>·</u>
	Bendi	ng			Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to 0	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crush	ed/Crimped		[	Burrs	Г	Instructi	ions Incomplete/Unclea	r $\lceil$	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	•	
	Heat 1	reat			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspec	tion Strip ir	1 Tube		Cut Too Short		Misread			Power Loss/	'Surge	Other
	Ripple	s in Bend			Drill Holes			-				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio



DESIG	ಎ	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHEC	STRY	BW	D350-615 REV. E
DATE 97.1	0.21		GROUND HANDLING WHEEL MOD. NTS
Α		95.03.23	NEW ISSUE
В		97.10.21	CHANGE NUMBERING SCHEME

-041	Part No.	Description								
X	D350-615-041	Ground Handling Wheel Mod.								
1	D2282-041	"T" ASSEMBLY								
1	D2282-043	SADDLE ASSEMBLY								
3	5/16-18-015C	5/16 BOLT 1.5 LONG								
3	5/16-18NC	5/16 LOCKNUT (D3015-3)								
12	5/16WC	5/16 WASHER								
1	7/16-14-050C	7/16 BOLT 5.0 LONG								
1	7/16-14NC	7/16 LOCKNUT (D3015-5)								
2	7/16WC	7/16 WASHER								

# THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH

THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

#### **INSTALLATION:**

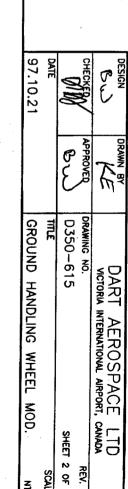
- 1. Remove existing ground handling wheel pump saddle.
- 2. Replace saddle with D350-615-041.
- 3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

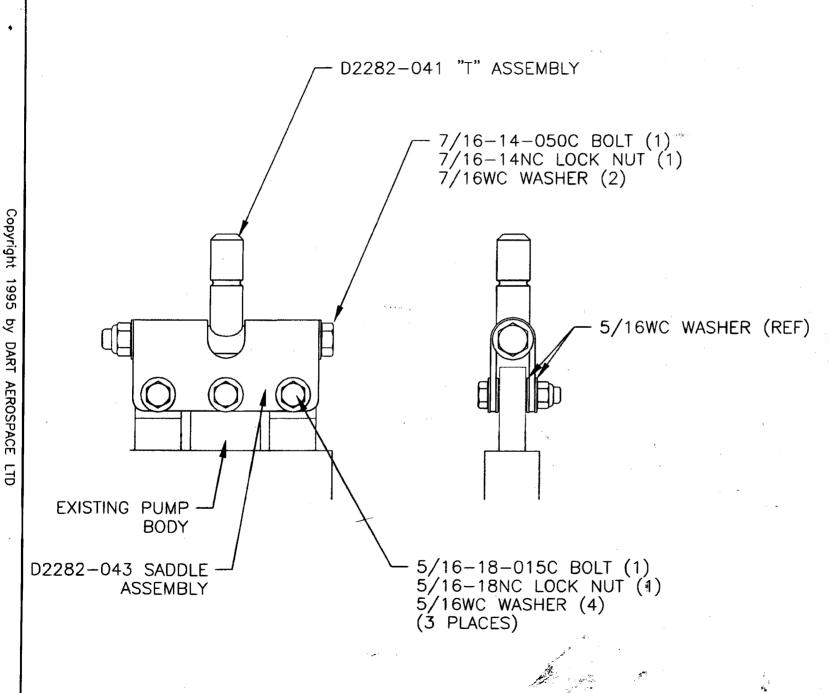
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NCR:	Yes / No	WORK ORDER NON-CONFORMANCE	/ UPDATE	<del></del>		

										QA Closed:	Date:	
Work Orde	r:				DISPO	OSITION			AGAINST DI	EPARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	<b>⊣</b>	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Cause	Date	Step	Qty		or Non-conform	- · ·	Chief En	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					:				:		- <i></i>	
						F	AULT CAT	GORY		· ·		I
Landin	g Gear				Gener	al						
-	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence				Bend BOM/Route Broken/Damag Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	ged	Instructure Maint Mislab Misrea Offset Out of	tion Incomplete tions Incomplete enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	ist in Tub	e	<b></b>	Folio	Outsid	e Dimensions					

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										DQA:	Date:	
NCR:	Yes / No				<b>WORK ORDER NON-</b>	COI	<b>NFORI</b>	MANCE / UPDATE				**
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Work Ora	er:		<del> </del>	<u> </u>	Rework	7		Skid-tube Crosstube		1	Water Jet	Engineering
Part No.					Scrap	-	١,	Machining Small Fal	_	Pro	d. Eng. Coor.	Quality
raiti	···			<del></del>	Use-as-is	1		noforming Finishing	_	4	e/Packaging	Other
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Root				Descri	ption of work order update	$\prod$	nitial	Action		Sign &		
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Bending					Bend		Grain	The second of the second	۰	Ovalized	—	Pressure/Forced
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Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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